

Work Order ID 127092 -2 Split 1/1

127092

Page 1

Monday, December 08, 2014 9:53:15 AM

Item ID: D4095-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate AFT
 Start Date: 12/08/14 Start Qty: 8.00 Cust Item ID:
 Required Date: 12/12/14 Req'd Qty: 8.00 Customer:
 Reference:

Approvals: Process Plan: AA Date: 14-12-08 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4095	B

100	FLOW WATER JET	0.00				8	0		DAS 23 9-89 14-12-17
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100

Waterjet

FLOW CNC Waterjet

304 .063"

Memo

1-Cut as per Dwg (D4095-3)

Dwg Rev: 12

Prog Rev: 3

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		DAS 23 9-89 14-12-17
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110

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00				8			DAS 38 9-89
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120

QC

Quality Control

Memo

DEC 18 2014

Monday, December 08, 2014 9:53:15 AM

Page 2

Large Fab

Work Order ID 127092

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127092

Page 4

Item ID: D4095-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate AFT
 Start Date: 12/08/14 Start Qty: 8.00 *g* Cust Item ID:
 Required Date: 12/12/14 Req'd Qty: 8.00 *g* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

4

DAS

38

AUG 07 2015

x4 of 11 12/08/14

MCS

AUG 10 2015

MCS

AUG 10 2015

Picklist Print

Monday, December 08, 2014 9:53:20 AM

Page 1

Work Order ID: 127092

127092

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate AFT

Start Date: 12/08/14

Required Date: 12/12/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA		Purchased	No			100	sf	167.0096	2.275	20			DAS
										14			23
										**			9-89
													14/12/17

M304S16GA

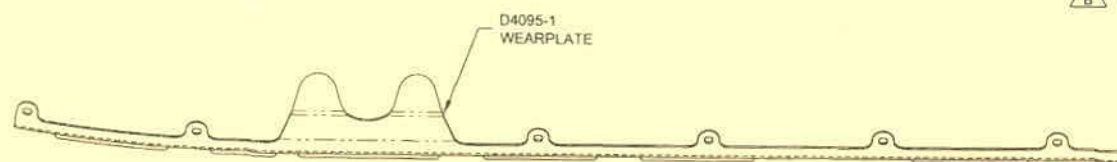
304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT019	167.0096	
M127821	71.317	
M129449	88.2412	
M130745	7.4514	

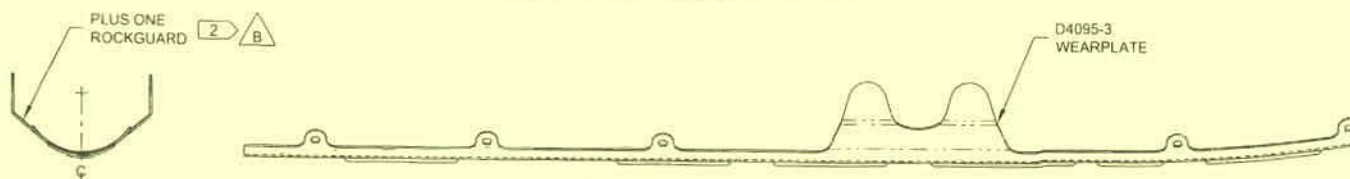
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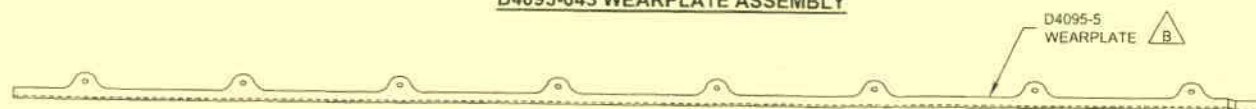
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARD COAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		
DE APPR.	10		
DATE	11.10.18		

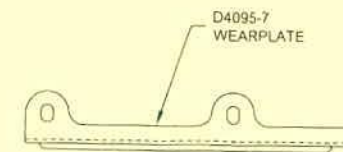
DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. D4095
TITLE WEARPLATE
SCALE NTS

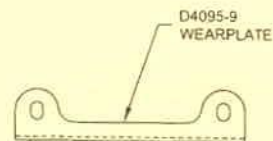
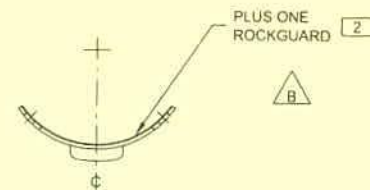
REV. B
SHEET 1 OF 8

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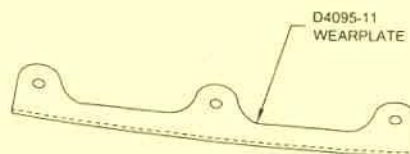
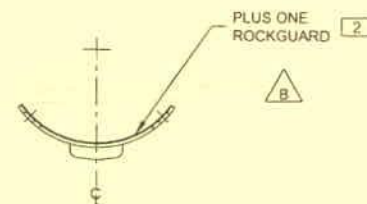
Handwritten: 4714-12-88
127002



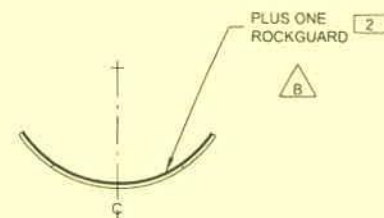
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY

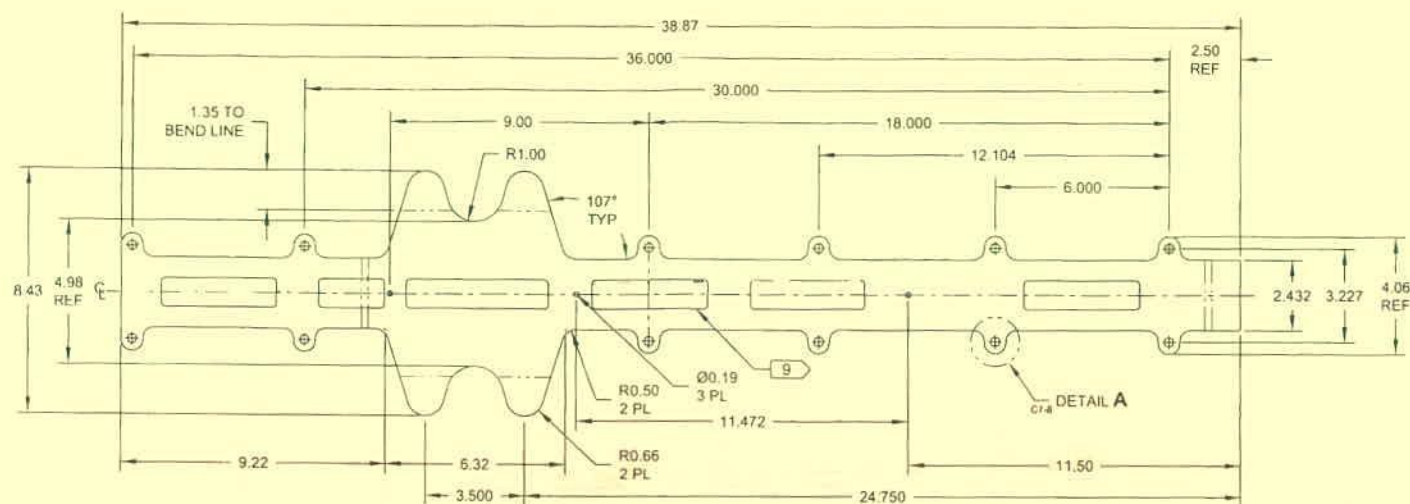


D4095-051 WEARPAD ASSEMBLY

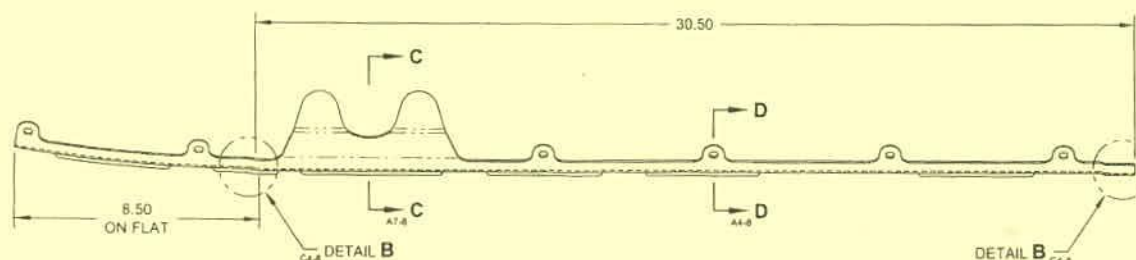


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2011-10-31
MB

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG APPR.	10	D4095	SHEET 2 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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D4095-1F FLAT PATTERN 1



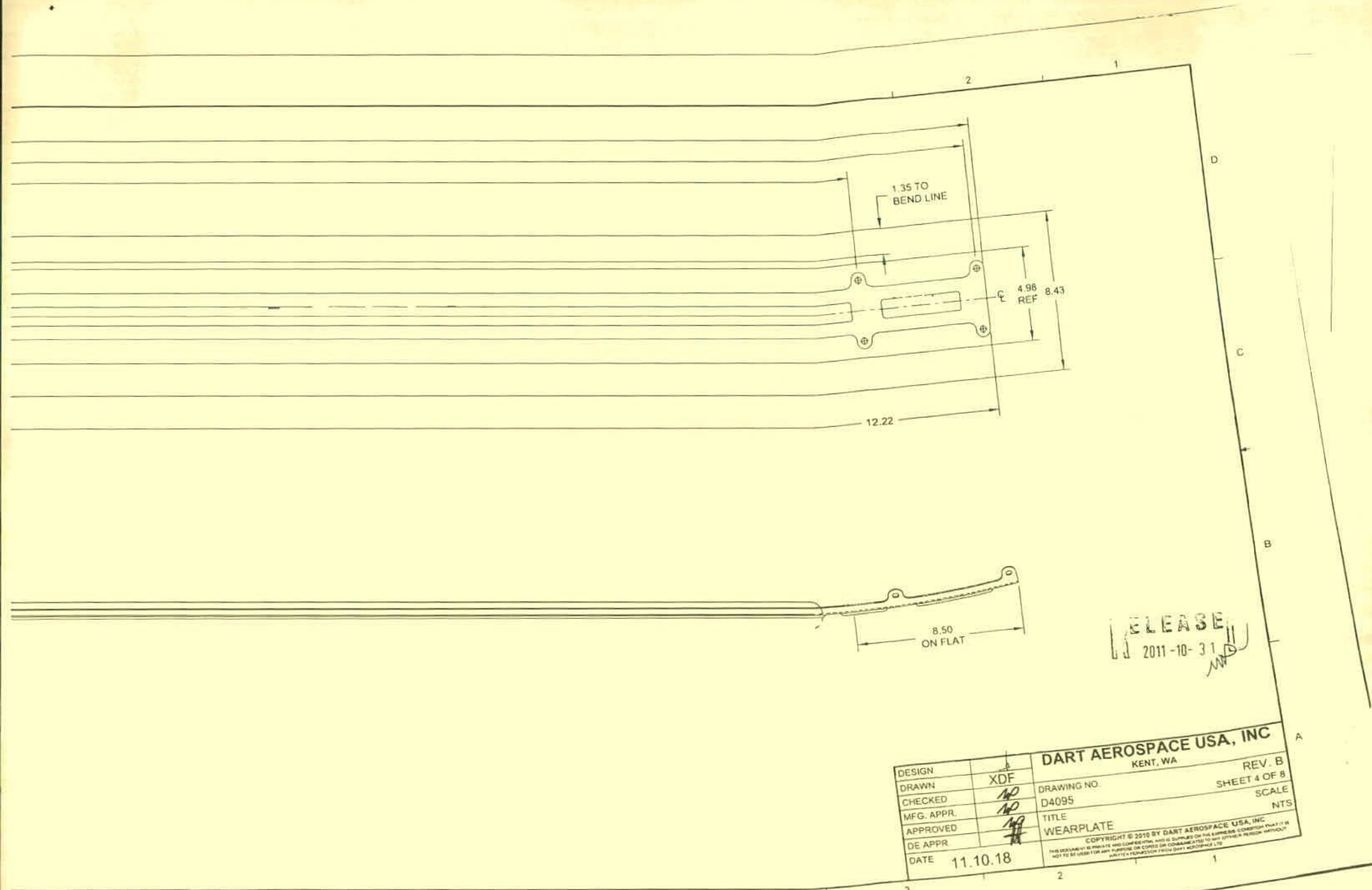
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/1F/3/3F/5/5F/7/7F/9/9F/11/11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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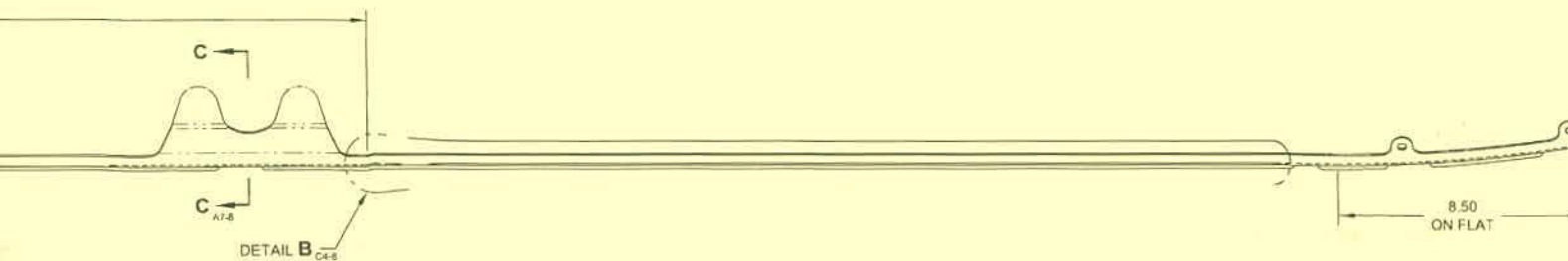


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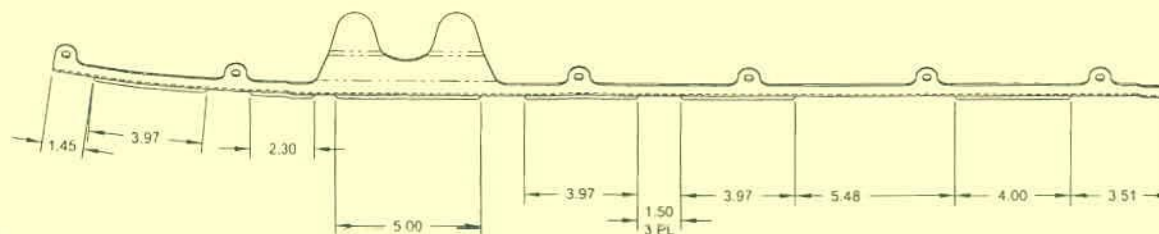
1 AT PATTERN 1



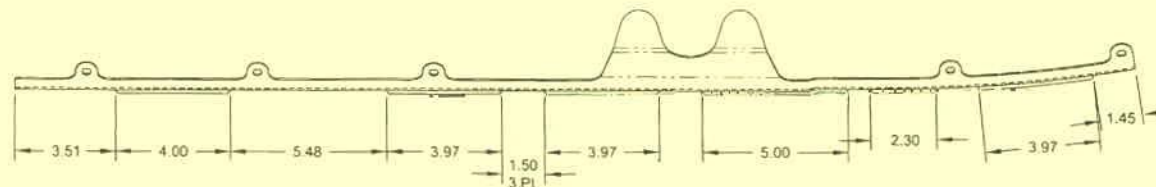
ENDING DETAIL
FROM D4095-3F)

RELEASE
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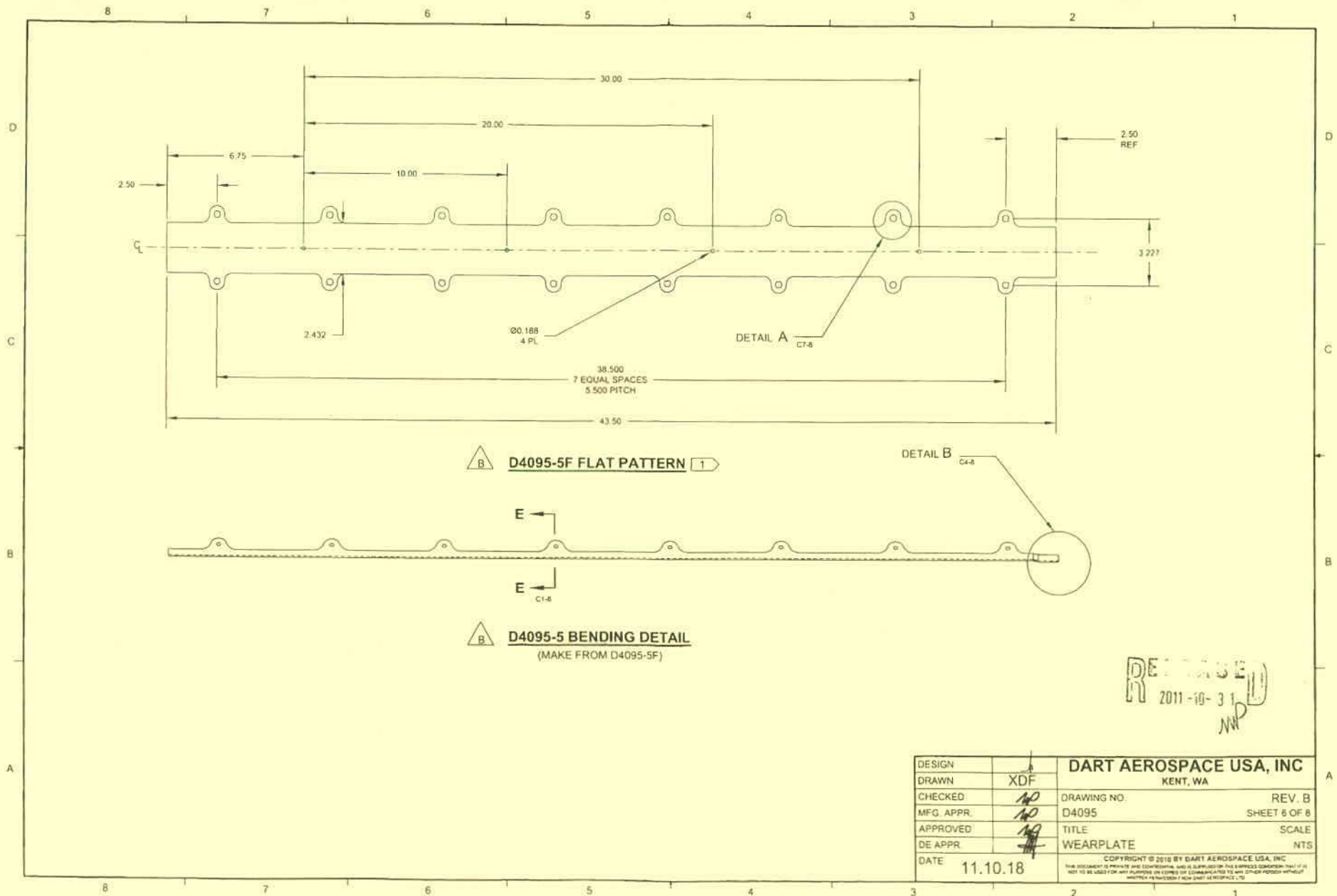
D4095-1 WELDING DETAIL 

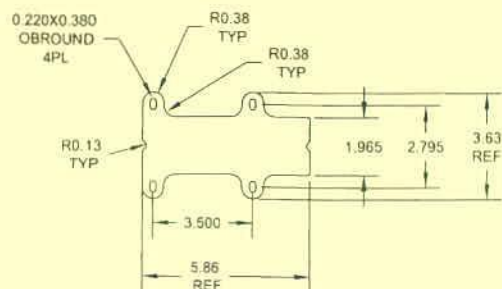


D4095-3 WELDING DETAIL 

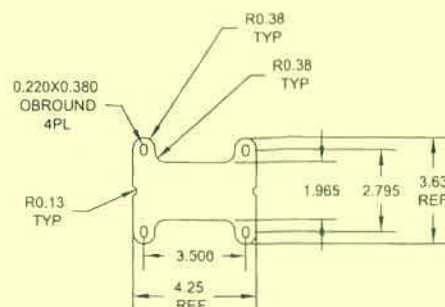
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MFG. APPR.		D4095	SHEET 5 OF 8
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DE APPR.		WEARPLATE	NTS
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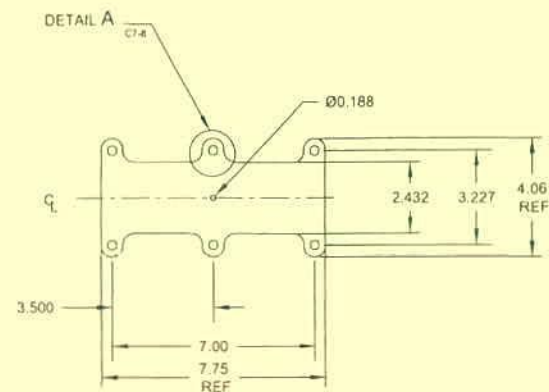




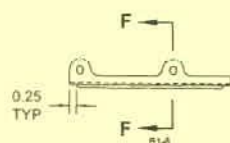
D4095-7F FLAT PATTERN 1



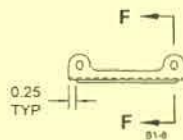
D4095-9F FLAT PATTERN 1



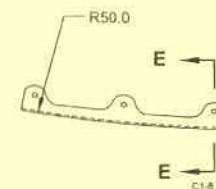
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



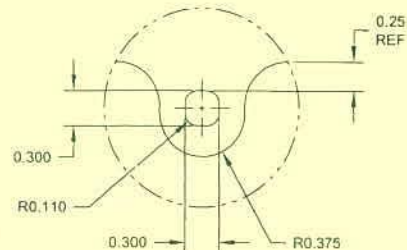
D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31
ANT

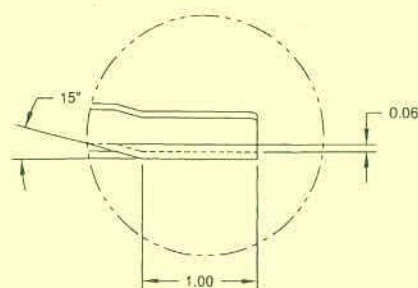
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DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO	REV. B
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APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	NTS
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DETAIL A: TAB DETAIL

SCALE 4X

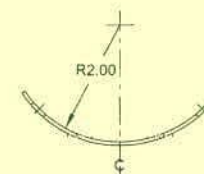
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

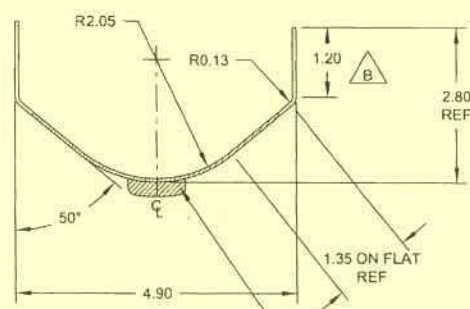
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

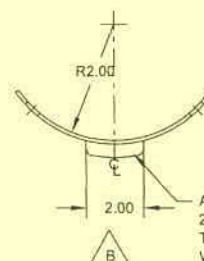


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

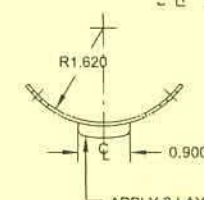


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

DESIGN	A	DART AEROSPACE USA, INC	
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